

48

SPLIT

DART AEROSPACE LTD	Work Order:	21711
Description: Wearpad	Part Number:	D2648-3
Dwg: D2648 Rev. D	Qty:	175 400
		Page 1 of 1


Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller RF 02.05.12 <i>Dwg not required</i>	KJ	04.10.18	400
2	PG	Issue P/O: 7006989 Email or ship DXF file to vendor Make per Drawing D2648-1 Material release note required	9	04.10.20	400
3	RG	Receive and Inspect for transit damage Ensure the material release note attached	11	04.11.09	358
4	QC6	Inspect dimensions	11	04.11.12	358
5	GA	Deburr if necessary	N/A		
6	GB	Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326 and identify as D2648-3	SRB	05/05/02	290 PTO
7	WS	Weld as per Dwg D2648 using Jig DT 8210 Qty Description Batch A/R 7560Hardcoat M17432	CPL	05/05/17	175
8	WS	Remove any weld that penetrated through Wearpad if necessary	CPL	05/05/17	175
9	QC9	Inspect weld	2	05-05-17	175
10	QC5	Inspect work to Step 9	11	05 07 04	175
11	FP	Powder Coat Grey (RAL-7012) (Ref. 4.3.5.5) per QSI 005 4.3	TC	050826	175
12	QC3	Inspect Powder Coat	11	05 08 29	175
13	FP	Identify and Stock	11	05 08 25	175
14	AC	Cost / part 6.07	JAC	05.08.30	175
15	DC	Close W/O 5.75 Inspect Level 21	11	05-08-29	175


Rev	Date	Change	Revised By	Approved
A	97.12.04			
B	99.04.09	Re-format	DM	
C	00.06.22	Removed P/O for powder coat	EC	
D	00.11.15	Removed Bending	EC	
E	02.09.18	Re-format; Incorporated D2648-1	KJ RF	

RELEASED
02/09/18 RF

H:\Irons...

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/05/07	6	Two taken for Eng						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/08/30

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 18, 2004
10:19 am

Work Order No : 0021711
Project Name : D2648-3
Project For : WK448
Work Order Type : Main
Main WO Number :
House Part Number : D2648-3
Description : Wearpad
Manufactured : Yes
Amount Req'd : 400
Amount Done : 0
Start Date : 10-18-04
Est Finish Date : 11-25-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



宝山钢铁股份有限公司
BAOSHAN IRON & STEEL CORPORATION LTD.

产品质量证明书

INSPECTION CERTIFICATE

上海市宝山区同济路1800号 邮编 201900
1800 TONGJI ROAD, BAOSHAN DISTRICT
201900 SHANGHAI, P. R. CHINA
TEL (021) 26645386
FAX (021) 56601754

订货单位 CUSTOMER	宝钢集团国际经济贸易总公司	P0030205002	产品名称 PRODUCT	COLD ROLLED STEEL SHEET IN COIL		
收货单位 PURCHASER	宝钢集团国际经济贸易总公司		代号 CUSTOMER'S NO.	000155	证书号 CERTIFICATE NO.	SFTG0630D00 01
标准 SPECIFICATION	ASTM A366 CQ PT.A-PW.A		客户订单号 CUSTOMER ORDER NO.			
			签发日期 DATE OF ISSUE	2000/07/06	交货日期 DATE OF DELIVERY	2000/07/03
			许可证号 LICENSE NO.		合同号 CONTRACT NO.	LA30050J02

序 号 NO.	钢 卷 号 COIL NO.	捆 包 号 PACK NO.	件 数 QTY	炉 号 HEAT NO.	规格及重量 MATERIAL DESCRIPTION					化学成分 CHEMICAL COMPOSITION % (熔体分析 MET ANALYSIS)														拉伸试验 TENSILE TEST (G L = L 2)				弯 曲 BEND TEST	硬度 HARD NESS	冲击 IMPACT KV	其他 OTHER
					厚度 THICK	宽度 WIDTH	长度 LENGTH	张数 SHEETS	重量 MASS (kg)	D	Si	Mn	P	S										屈服 Y.S.	抗拉 T.S.	伸长 EL	断后 断后				
					mm	mm	mm			x10 ⁻³	x10 ⁻³	x10 ⁻³	x10 ⁻³	x10 ⁻³	x10 ⁻³	x10 ⁻³	x10 ⁻³	x10 ⁻³	x10 ⁻³	x10 ⁻³	x10 ⁻³	x10 ⁻³	x10 ⁻³	MPa	%	%	值				
1	1450051	02	1	125420					8890	4		23	16	13										275	361	34				55	
2	1450051	03	1	125420					8880	4		23	16	13										275	361	34				55	
3	1450053	01	1	125420					6880	4		23	16	13										275	363	38				57	
4	1450053	02	1	125420					6760	4		23	16	13										275	363	38				57	
5	1450053	03	1	125420					6730	4		23	16	13										275	363	38				57	
6	1450053	04	1	125420					6760	4		23	16	13										275	363	38				57	
7	1450054	02	1	125423					8680	4		24	18	11										270	356	39				54	
8	1450054	03	1	125423					8530	4		24	18	11										270	356	39				54	
9	1450054	04	1	125423					8290	4		24	18	11										270	356	39				54	
10	1450055	02	1	125424					8620	3		23	14	11										268	351	40				55	

合计 Total

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SIZE: 0.0350 "NOM X48.000" X

备注
REMARKS注释
NOTESY.S. = YIELD STRENGTH
*01: HRB *02: HRBT.S. = TENSILE STRENGTH
*03: HRB *04: HRBEL = ELONGATION
*05: HRB *06: ERICHSEND.L. = GAUGE LENGTH
*07: HRB *08: ERICHSEN

L1 = 5.08307 (F0)

L2 = 50MM L3 = 80MM

会签者
SURVEYOR TO

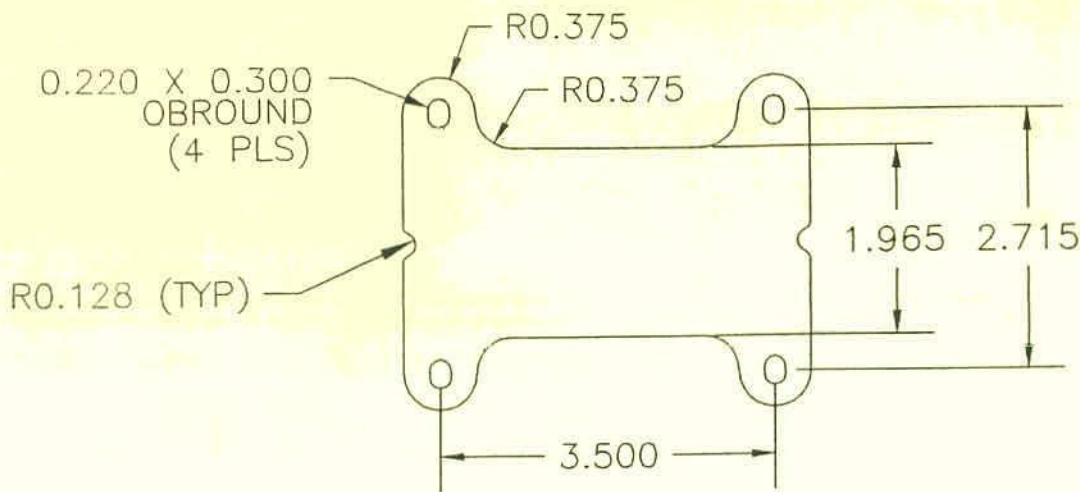
本产品已按上述要求进行制造和检验,其结果符合要求,特此证明。
WE HEREBY CERTIFY THAT MATERIAL DESCRIBED HEREIN HAS MANUFACTURED AND TESTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE
MATERIAL SPECIFICATION.

技术部部长
DIRECTOR OF TECHNICAL DEPT.

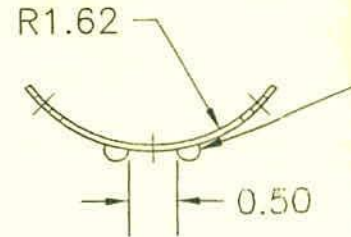
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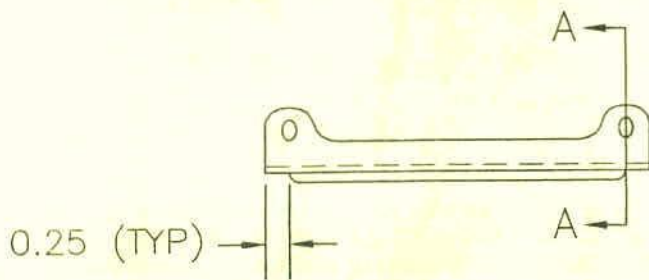
D2648-1 FLAT PATTERN



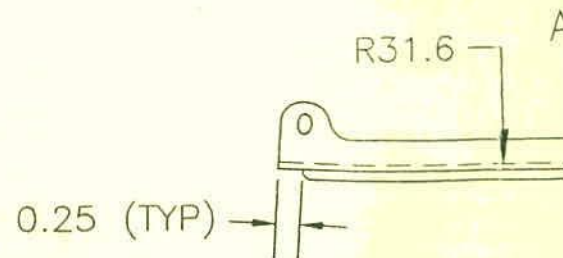
SECTION A-A



D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-5 LONGIT (MADE FROM D2648-1)



BREAK ALL SHARP CORNERS 0.063 MAX
 MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063
 FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
 TOLERANCES ARE PER DART, QSI 018 UNLESS OTHERWISE NOTED
 ALL DIMENSIONS ARE IN INCHES

